

# Work Order ID 86597

**\*86597\***

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July-05-12 1:19:34 PM

Item ID: D3914-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Long Basket Lid Assembly (350)  
 Start Date: 7/05/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 8/10/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: CL Date: 12/07/05 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	B
D4020	A

100 Weld per dwg A/R S.S. rod Batch: 122130 0.00  
 Large Fab  
**\*100\***  
 Large Fab Memo 0.00  
 Large Fab 1- assemble ribs , weld as per dwg D3914 using DT9607A  
 2- weld hinge (3) and Mounting brackets as per dwg D3914  
 \*\*\*Visual inspect before welding mesh\*\*\*  
 3- tack weld mesh on basket as per dwg D3914  
 \*\*\*Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control

1x CL 12.8.03

1 8 12-08-27  
 DAS 18-89

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC5- Inspect part completeness to step on W/O 0.00

**\*120\***

QC

Quality Control

Memo

0.00

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

**\*130\***

Powdercoat

Powder Coating

Memo

0.00

\*\*\* mask sides of hinge prior to powdercoat\*\*\*  
 Start Time: 1:45  
 Oven Temperature: 320°F  
 Finish Time: 2:15

140

Wing Walk as per dwg QSI005 4.4 Batch 100300 0.00

Memo

0.00

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

\*\*\*Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label\*\*\*

F  
H

W/O:		WORK ORDER CHANGES					
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**\*86597\***

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## Quality Control

1 ~~2~~ (2) 12/08/27

1 φ BL/28-28.

OK 12/8/29.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 86597

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/05/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
10.08.18 verified by:EC

IPP Rev:B as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2581 Mounting Bracket		Manufactured	No			100	Each	61.0000	2	2		PC12.8.23	

Location	Loc Qty	Loc Code
WA	39	
82506	2	
83230	3	
85436	10	
85452	24	
WA005	22	
70766	2	
81253	1	
82897	19	

D2728-3  
Dart Logo label

Manufactured No

140 Each 0.0000

1 1

BL 12.8.27

✓ D3914-1  
Rib

Manufactured No

100 Each 16.0000

2 2

PC12.8.23

Location	Loc Qty	Loc Code
WA	-2	
86044	14	
WA006	18	
81449	1	
82131	1	

387079 → (2)

✓ D3914-7  
Rib

Manufactured No

100 Each 9.0000

2 2

PC12.8.23

Location	Loc Qty	Loc Code
WA	-5	
81209	1	
WA006	14	
82928	3	
86165	5	

387853 → (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

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Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/05/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

✓ D4016-3  
Hinge Half, Lid

Manufactured No

100 Each 19.0000

3 3

*Pl 12.8.23*

Location

Loc Qty

Loc Code

WA  
84777  
WA005  
85776

1  
1  
18  
18

387628 → ②

✓ D4018-5  
Rib

Manufactured No

100 Each 43.0000

9 9

*Pl 12.8.23*

Location

Loc Qty

Loc Code

WA  
85728  
86325  
WA005  
80776

42  
24  
18  
1  
1

388675 → ⑨

✓ D4020-5  
Mesh (350 Basket Long, Lid)

Manufactured No

100 Each 4.0000

1 1

*Pl 12.8.23*

Location

Loc Qty

Loc Code

WA  
85410

4  
4

388398 → ①

✓ D4021-3  
Data Plate

Manufactured No

100 Each 17.0000

1 1

*Pl 12.8.23*

Location

Loc Qty

Loc Code

WA  
80897  
82507  
85358

17  
9  
1  
7

387957 → ①

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 86597

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/05/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-041 Manufactured No  
Lid Rib Assembly, Fwd (350 Basket)

100 Each 11.0000

1

1

*Cpl 12.8.23*

Location

Loc Qty

Loc Code

WA

11

63720

0

82985

2

82986

9

①

✓ D4035-043 Manufactured No  
Lid Rib Assembly, Aft (350 Basket)

100 Each 12.0000

1

1

*Cpl 12.8.23*

Location

Loc Qty

Loc Code

WA

11

81452

1

82988

10

WA006

1

81202

1

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

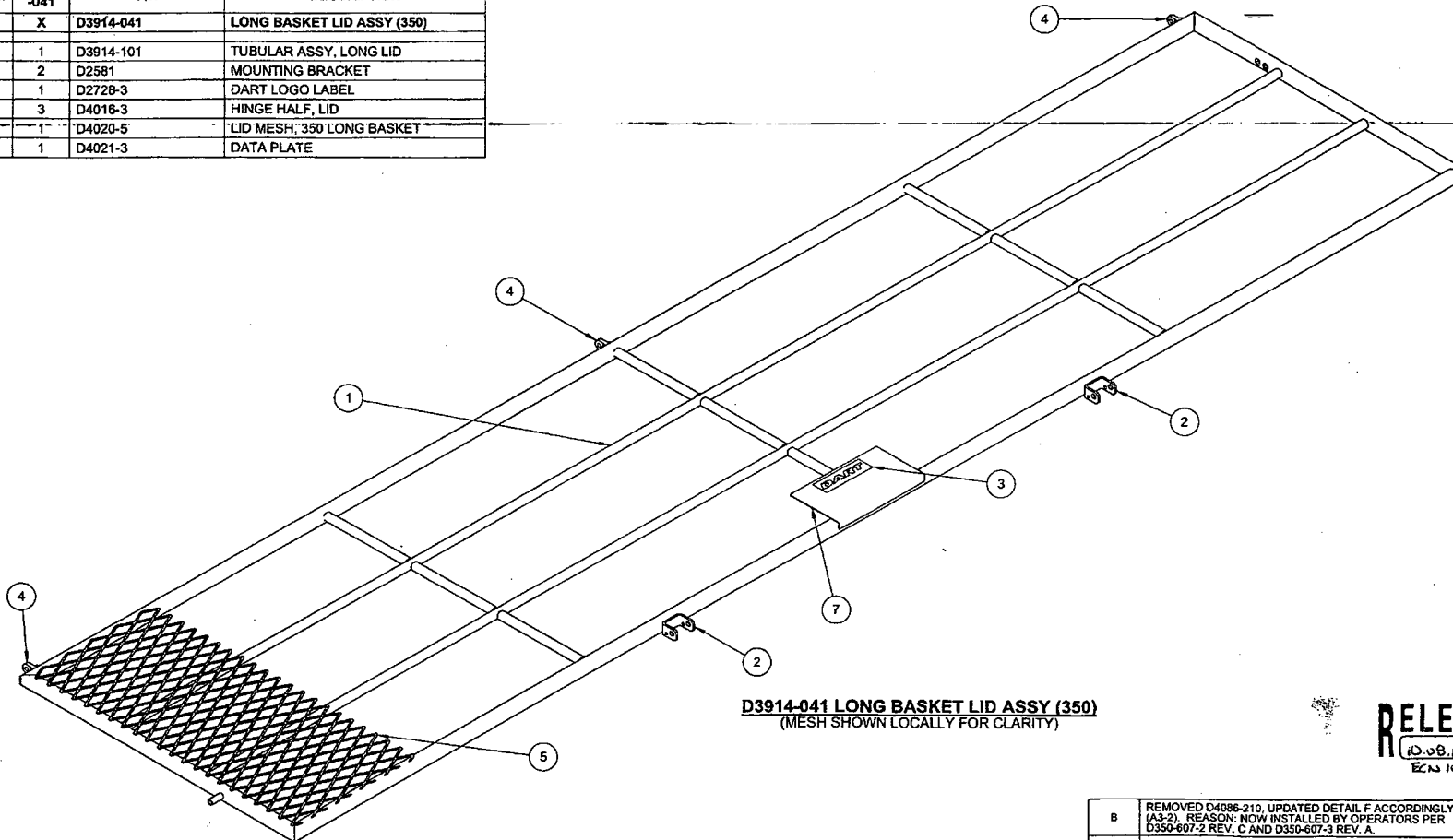
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

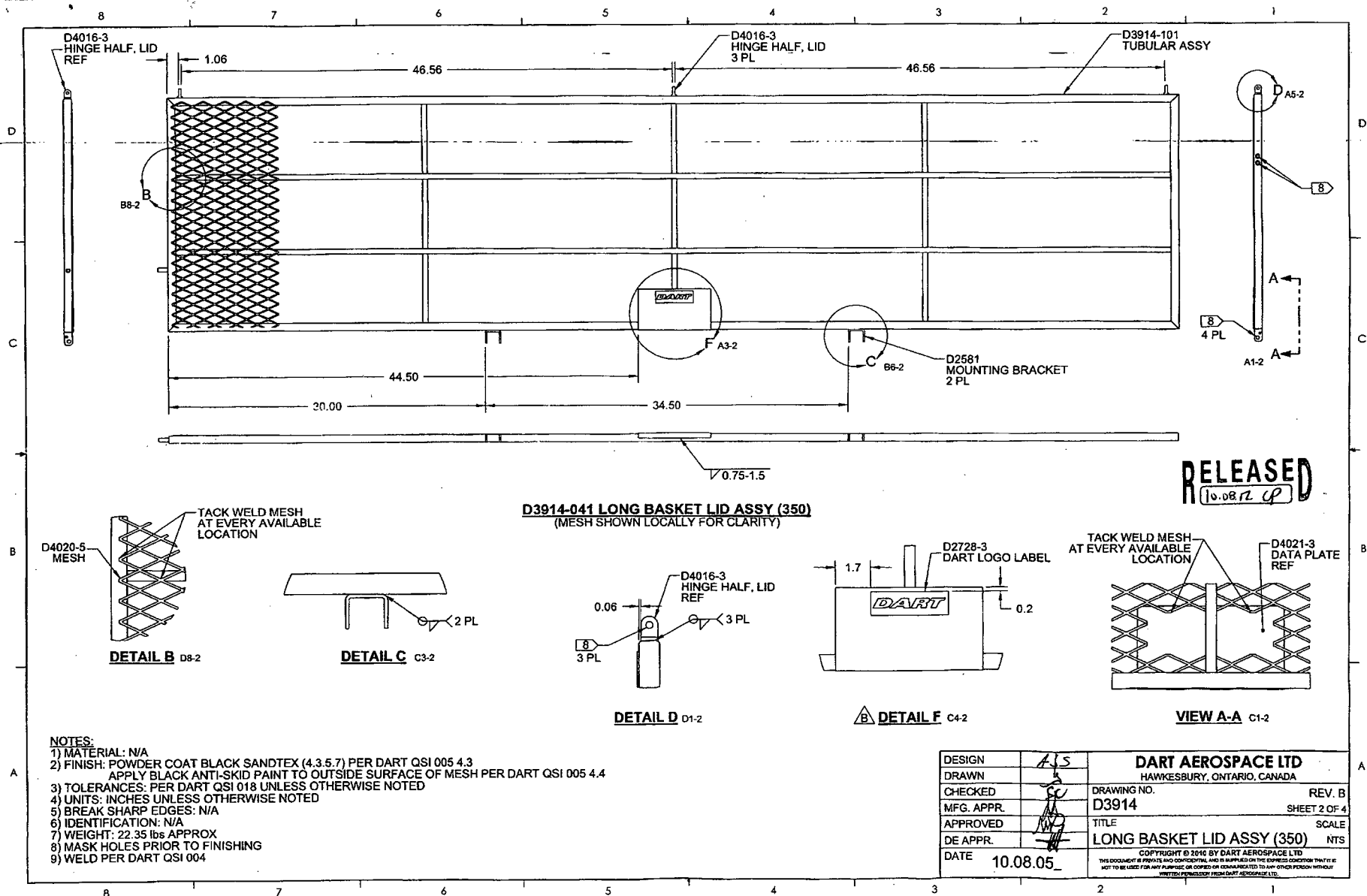
**RELEASED**  
10.08.17  
ECN 10-596

CL 12/07/05  
W10: 86597

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	10.08.05		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3914	REV. B
TITLE LONG BASKET LID ASSY (350)	SHEET 1 OF 4
SCALE NTS	
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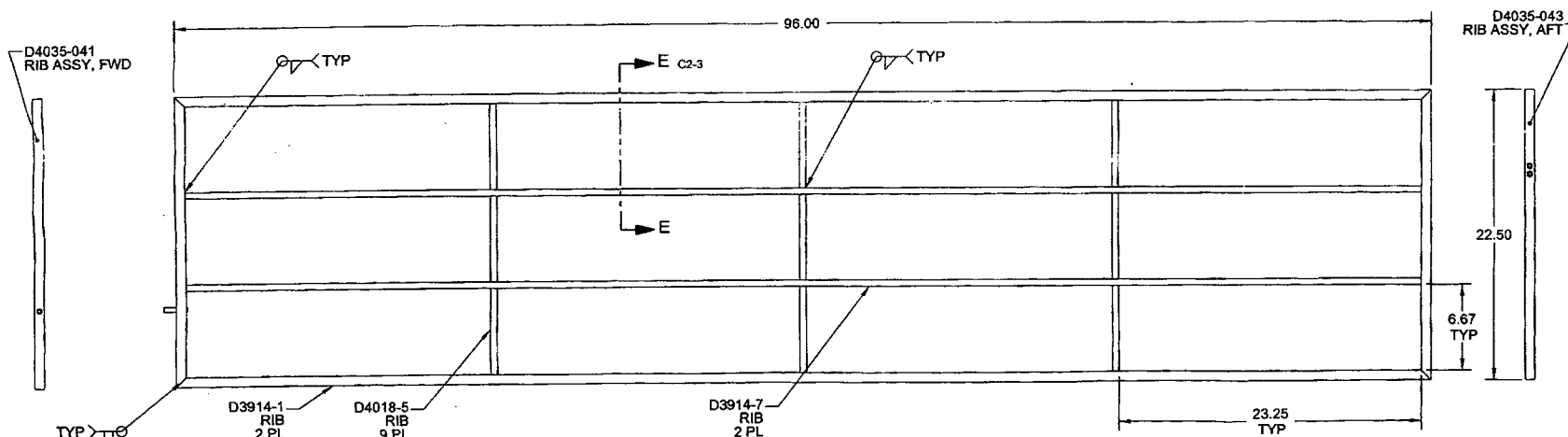
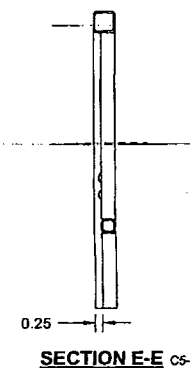








ITEM	QTY	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



**D3914-101 TUBULAR ASSY, LONG LID**

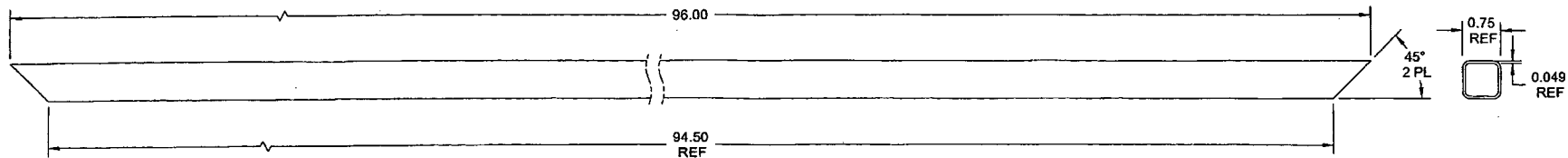
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

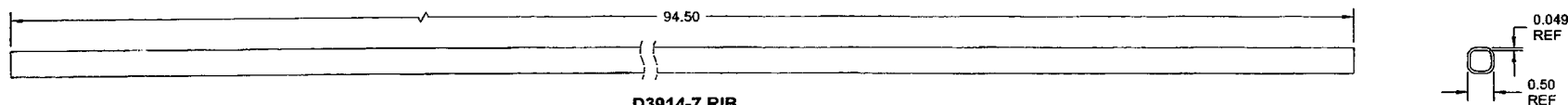
**RELEASED**  
10.08.12

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	RC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RC	DRAWING NO.	REV. B
MFG. APPR.	RC	D3914	SHEET 3 OF 4
APPROVED	RC	TITLE	SCALE
DE APPR.	RC	<b>LONG BASKET LID ASSY (350)</b>	
DATE	10.08.05	NTS	
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**D3914-1 RIB**



**D3914-7 RIB**

**NOTES:**

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

**RELEASED**  
10.08.12.07

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.		D3914	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

